

Date: Sunday, 12/4/2005 12:45:11 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 25089C		
Estimate Number	: 10354		
P.O. Number	: N/A	Part Number	: D2322
This Issue	: 12/4/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2322 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24533C	Drawing Revision	: C
		Material	: N/A
		Due Date	: 12/12/2005
Written By	: <u>SEE COMMENT BELOW</u>	Qty:	30
Checked & Approved By	: <u>SEE COMMENT BELOW</u>	Um:	Each
Comment	: Est Rev:A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2132 sf(s)/Unit Total : 4.2630 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2322
 Batch: 119059

2.0	SHEAR	SHEAR J.L
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Comment: SHEAR
 Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500")

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 J.L
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2322, use stack of 15

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE J.L
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

9ml 05/12/11 30

W/O: WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr
								Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/19
 QA: N/C Closed: _____ Date: _____

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Sunday, 12/4/2005 12:45:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 25089C

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 1 12/17/05 / 30

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2322

SB 06/01/16 30

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-16 30

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/01/18 30

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-01-18 30

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 37

06/01/17 30

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAD 06/01/19 (30) 06/01/19

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		CP		HAMKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	MM	DRAWING NO.	REV. C
DATE		TITLE		SHEET 1 OF 1	
98.09.29		STEP SPACER		SCALE	
A		94.10.14		NEW ISSUE	
C		98.09.29		4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	

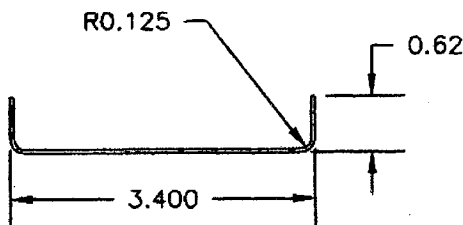
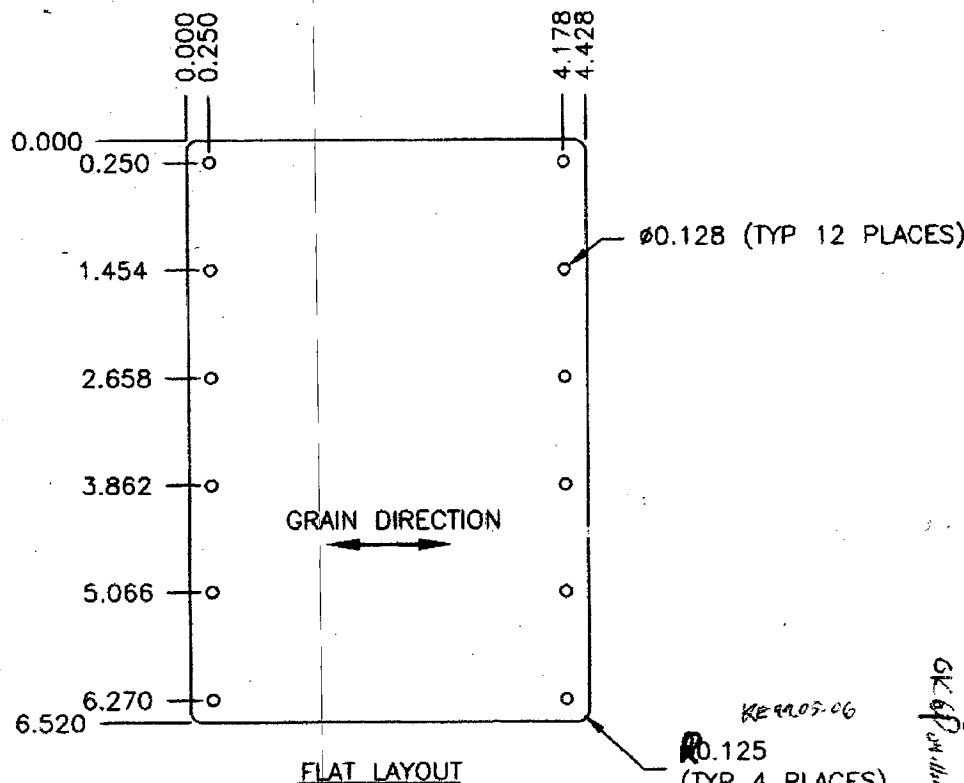
RELEASED
18.10.08 DS**UNDER REVIEW**

01.03.15 CP

DESIGN OK, BUT CHECK WITH
MFG BEFORE MANUFACTURE

OK CP 01/03/15

RE 99.05.06

R0.125
(TYP 4 PLACES)

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED